

Work Order ID 148201

Monday, June 27, 2016 11:41:38 AM

148201

Page 1

Item ID: D3681-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Spacer

Start Date: 6/30/2016

Start Qty: 60.00

60

Cust Item ID:

Required Date: 7/7/2016

Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan:

DAS
13
9-89

Date: JUN 27 2016

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3681	Rev A								
100	Hardinge CNC LATHE SMALL	0.05							DAS 49 9-89
100									
Hardinge	Memo	0.20							
Hardinge CNC Lathe Small	1-TURN AS PER FOLIO FA711& DWG D3681								
	FOLIO REV: _____								
	DWG REV: _____								
	2-DEBURR AS REQUIRED								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 49 9-89
110									
QC	Memo	0.10							
Quality Control									
120	QC8- Inspect parts - second check	0.00							DAS 44 9-89
120									
QC	Memo	0.20							
Quality Control									

m60G1T6T0.3125 w/ 147557
w. 058

90

80

80

80

16/08/27

16/08/27

16-08-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Work Order ID 148201

Monday, June 27, 2016 11:41:38 AM

148201

Page 2

Item ID: D3681-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacer
Start Date: 6/30/2016 Start Qty: 60.00 ***60*** Cust Item ID:
Required Date: 7/7/2016 Req'd Qty: 60.00 ***60*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125		0.00							
125						80	0	8E16-07-08	
Skidtubes	Memo	0.20							
Skidtubes	1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.								
130	Identify as per dwg & Stock Location: <u>LG001</u>	0.00							
130						80	0	8E16-07-08	
Packaging	Memo	0.10							
Packaging	***STOCK IN SKIDTUBE CELL*** LOCATION : LG001								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	1.00							
Quality Control									

DAS
21
9-89 SEP 08 2016

DAS
21
9-89 SEP 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

Monday, June 27, 2016 11:41:38 AM

Page 1

Work Order ID: 148201

148201

Parent Item: D3681-1

D3681-1

Parent Item Name: Spacer

Start Date: 6/30/2016

Required Date: 7/7/2016

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev A new issue 07-10-30 DD verified by:EC
IPP Rev:B Ecn 1056 Rev A dwg DD
seq 125 DD 10.05.03 verified by:EC

IPP Rev:C add

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.05 8		Purchased		No		100	f	60.7500	0.34	21.47368	27.20		

M6061T6T0 3125W 058

ALUM TUBE .3125 x .058w

**

Location	Loc Qty	Loc Code
MAT013	60.75	
m133509	0.75	
m134504	36	
m134548	24	

135093

→ 30

DAS
49
9-89

16/08/27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

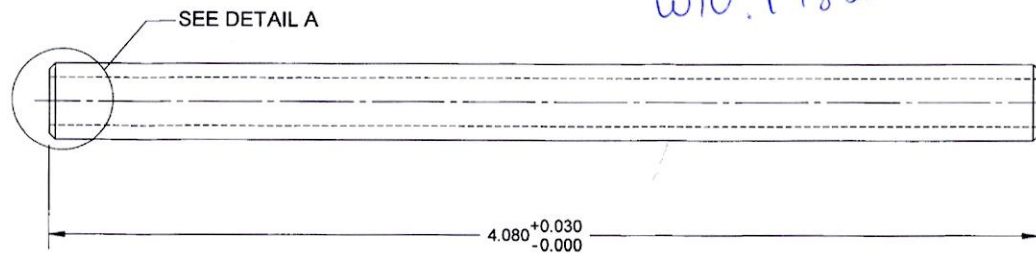
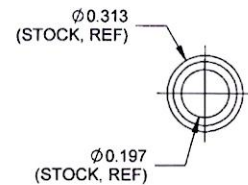
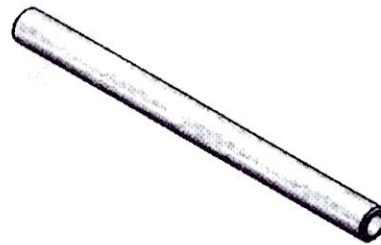
Work Order update only ☐

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DAS
13
9-09

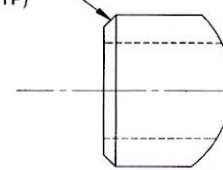
JUN 27 2016

W10:148201



D3681-1 SPACER

0.025 X 45°
CHAMFER
(TYP)



DETAIL A
(SCALE 4 : 1)

RELEASED
07-11-09

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

A		NEW ISSUE		DC	07.11.08
REV.		DESCRIPTION		BY	DATE
DESIGN	DL	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D3681 TITLE SPACER SCALE 2:1			REV. A
DRAWN	SC				SHEET 1 OF 1
CHECKED	MA				
MFG. APPR.	EP				
APPROVED	WJ				
DE APPR.	JA				
DATE 07.11.08		COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			